

Date: Tuesday, 22/08/2006 2:20:56 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28302
 Estimate Number : 11040
 P.O. Number : *NIA*
 This Issue : 22/08/2006 S.O. No. : *NIA*
 Prsht Rev. : NC
 First Issue : *NIA* Type : SMALL /MED FAB
 Previous Run : 28199
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est. A00.11.06 New Issue EC
 Est. B06.05.30 Blanks on wtjetEC

Drawing Name : STA 155 BRACKET

Part Number : D28042
 Drawing Number : D2804 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : *NIA*
 Due Date : 29/08/2006

Qty: 5 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X12000 6061-T6 Bar .50" x 12.0"



Comment: Qty.: 0.7875 f(s)/Unit Total : 3.9375 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: *M101263*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Template DT8534

Dwg Rev: *B*Prog Rev: *B*

2-Deburr if necessary

*SAD 06:08:22**5*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA103

*SA 06.08.22**4*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SA 06.08.22**4*

5.0 QC8 SECOND CHECK



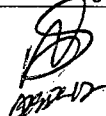

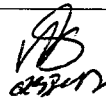
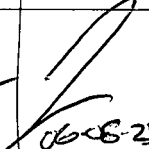
Comment: SECOND CHECK

*SA 06.08.22**4*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 2 Date: 06/08/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-08-23	1	1 plate scrap. Extremely deep gouges in the mat'l. from storage. Can not make -2, marks pass across the part.		Identify plate : marks, place aside to see if it can be used for A-1 which has less mat'l on the top side.	SD 06.08.23	 06-08-23		 06-08-23

NOTE: Date & initial all entries

Date: Tuesday, 22/08/2006 2:20:56 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 28302

Part Number: D28042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr

ML 06/08/24

4

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-08-29

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

DL 06/08/29

(4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *ST156*

DL 6/8/29
PB 06/08/29

(4)
(4)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

DL 06/08/30

Job Completion



C 06/08/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

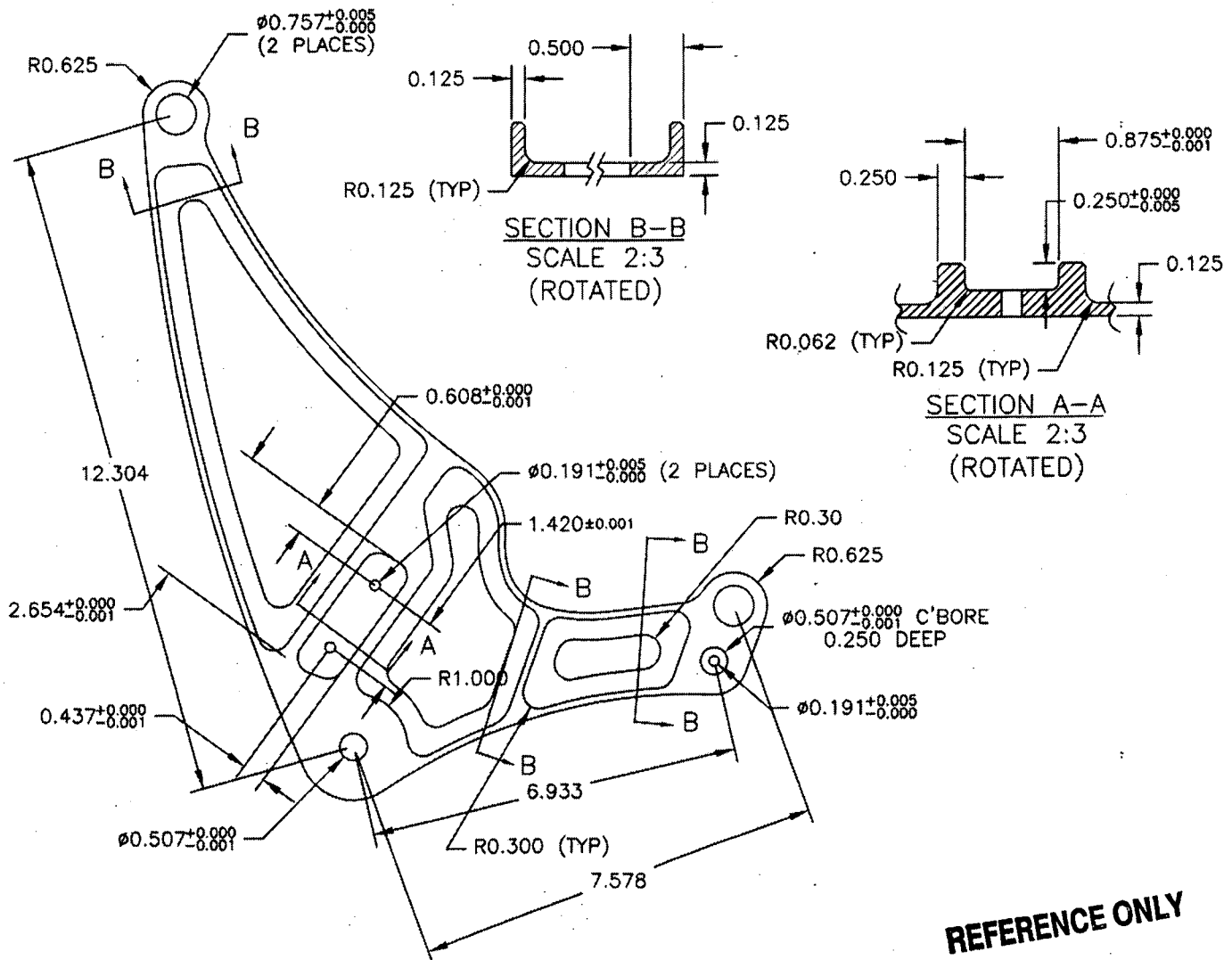
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2804	SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 155 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			

RELEASED

05-03-11 *[Signature]*

REFERENCE ONLY

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

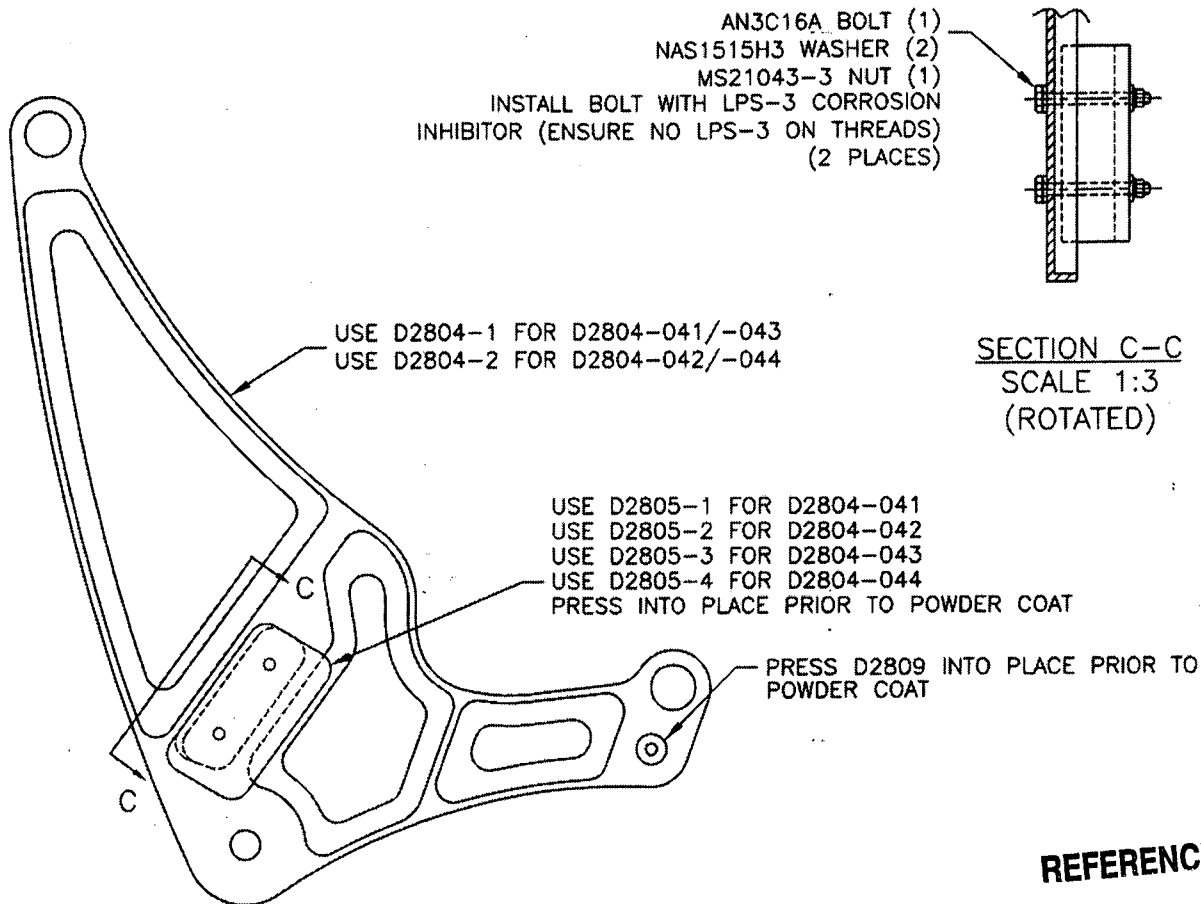
- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2804	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3



REFERENCE ONLY

RELEASED

05-03-11 [Signature]

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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DART AEROSPACE LTD		Work Order: 28302
Description: STA 155 Bracket		Part Number: D2804-2
Inspection Dwg: D2804	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.127	/			
0.125	+/-0.010	.130	/			
R0.125	+/-0.010	R.125	/			
0.250	+/-0.010	.250	/			
0.250	+0.000/-0.005	.249	/			
0.875	+0.000/-0.001	.874	/			
R0.062	+/-0.010	R.063	/			
Ø0.757	+0.005/-0.000	.757	/			
R0.625	+/-0.010	R.626	/			
12.304	+/-0.005	12.305	/			
Ø0.507	+0.000/-0.001	Ø.507	/			
0.437	+0.000/-0.001					
0.608	+0.000/-0.001					
Ø0.191	+0.005/-0.000	Ø.191	/			
1.420	+0.001/-0.001	1.419	/			
0.250 deep	+/-0.010	.245	/			
6.933	+/-0.005	6.933	/			
7.578	+/-0.005	7.579	/			
0.500	+/-0.010	.500	/			Mat. Thickness

Measured by: SA	Audited by: ml	Prototype Approval:	N/A
Date: 06.08.22	Date: 06/08/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	